

Date: Monday, 3/26/2007 3:22:27 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CUFF
Job Number : 31474	
Estimate Number : 12774	
P.O. Number : N/A	Part Number : D36061
This Issue : 3/26/2007 S.O. No. : N/A	Drawing Number : D3606
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : UNDER REVIEW
Previous Run : 31150	Material : N/A
Written By : <u>JA 07.03.26</u>	Due Date : 4/20/2007
Checked & Approved By : <u>JA 07.03.26</u>	Qty: 10 Um: Each
Comment : est rev A new issue EC	

Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description :
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1.0	M6061T6R3500	Inventory
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760919



Comment: Qty: 0.5250 f(s)/Unit Total: 5.2500 f(s)
 6061 T6 round bar 3.500" dia.
 batch: B20111

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

1-Turn as per folio FA & DWG D3606,
 FOLIO REV: N/A
 DWG REV: A

2-Deburr as required

B6 07.04.20

10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B6 07.04.20

10

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 07/04/20

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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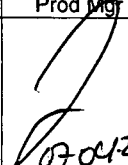
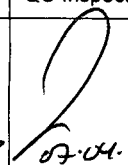


Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

Fxl

07/04/23

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.04.19	1	MATI # 7075 T6 / 6511 T6c Can make from D6006, D6008, D6009	BC	07.04.19			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/26/2007 3:22:27 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUFF

Job Number: 31474

Part Number: D36061

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2070423 (10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

2070424 (10)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2070424 (10)

Job Completion



U 2070424

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

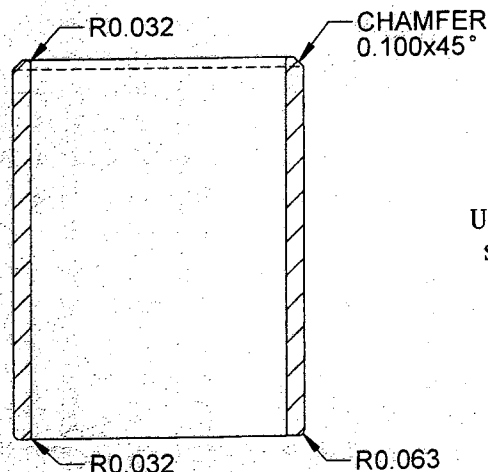
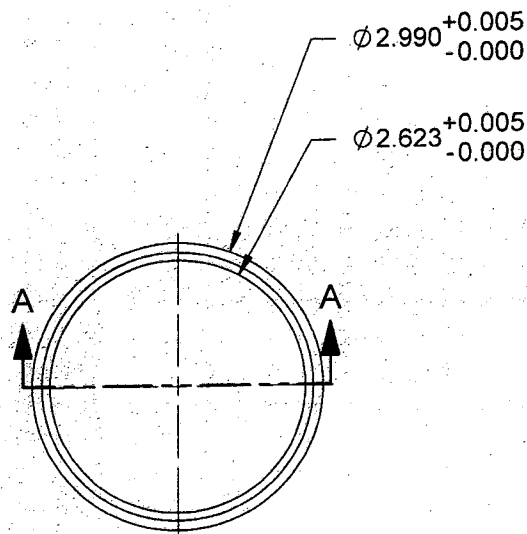
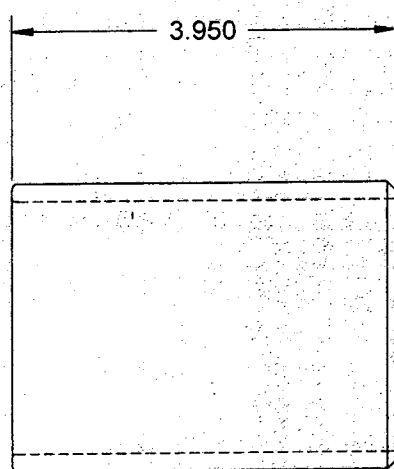
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN gp	DRAWN BY gp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3606	REV. A SHEET 1 OF 1
DATE 07.03.01	TITLE CUFF		SCALE 1:2
A	07.03.01	NEW ISSUE	

PRELIMINARY ISSUE**SECTION A-A**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31474

D3606-1 CUFF**NOTES:**

- 1) MATERIAL: 7075-T6/T6511 SEAMLESS TUBE (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11)
(CAN MAKE FROM D6006, D6008, OR D6009)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DAR QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD		Work Order:	
Description: Crosstube Assembly CUFF		Part Number:	D3606-1
Inspection Dwg: D3606 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	3.950	±.010	3.949	✓			
	φ 2.940	+0.005 -0.000	2.942	✓			
	φ 2.623	+0.005 -0.000	2.625	✓			
	R.032	±.010	.032	✓			
	R.063	±.010	.063	✓			
	.100 X 45°	±.010	.100	✓			
SIDE B							

Measured by: <i>RG</i>	Audited by: <i>QML</i>	Prototype Approval:	N/A
Date: 07.04.20	Date: 07/04/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	